

Date: Monday, 12/01/2009 9:12:18 AM
 User: Linda Lacelle

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : AFT DOUBLER
 Job Number : 44597
 Estimate Number : 13151
 P.O. Number :
 This Issue : 12/01/2009 S.O. No. :
 Prsht Rev. : NC Part Number : 637035
 Drawing Number : D3703 PRELIM
 Project Number : N/A
 First Issue : / / Type : SMALL / MED FAB Drawing Revision : PRELIM
 Previous Run : 05067 Material :
 Due Date : 12/01/2009 Qty: 5 Um: Each
 Written By :
 Checked & Approved By :
 Comment : Est Rev:A 08-04-24 new issue DD verified by:EC

Additional Product

PRELIMINARY ISSUE



Job Number:



5 cab. 12
 PBL BCN #09.502P

Seq. #: Machine Or Operation: Description:

1.0 M6061T6S063 6061-T6 .063 Sheet



Comment: Qty.: 0.0833 sf(s)/Unit Total: 0.4163 sf(s)

6061T6 aluminium sheet .063" thick

(M6061T6S063)

Batch: 108279

HB 9-1-13

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D3703

Dwg Rev: PRE

Prog Rev: LIM

HB 9-1-13

(6)

2- Deburr if necessary

HB 9-1-13

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



HB 9-1-13

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

ENGINEERING
 APPROVAL

09.01.15 (6)

HB 09-01-13

5.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

090114

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No **DOA** Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 12/01/2009 9:12:18 AM
User: Linda Lacelle

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT DOUBLER

Job Number: 44597

Part Number: D37035

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



HH



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09-01-14

(6)

7.0

PACKAGING 1

PACKAGING RESOURCE #1



dzus.



(6)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *128*

9/6/8

SL

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/08

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF 09-01-15

POSITIVE RECALL

EFFECTIVE *09-11-12* AUTH *LL*

RELEASED *5*

DATE *09-08-05*

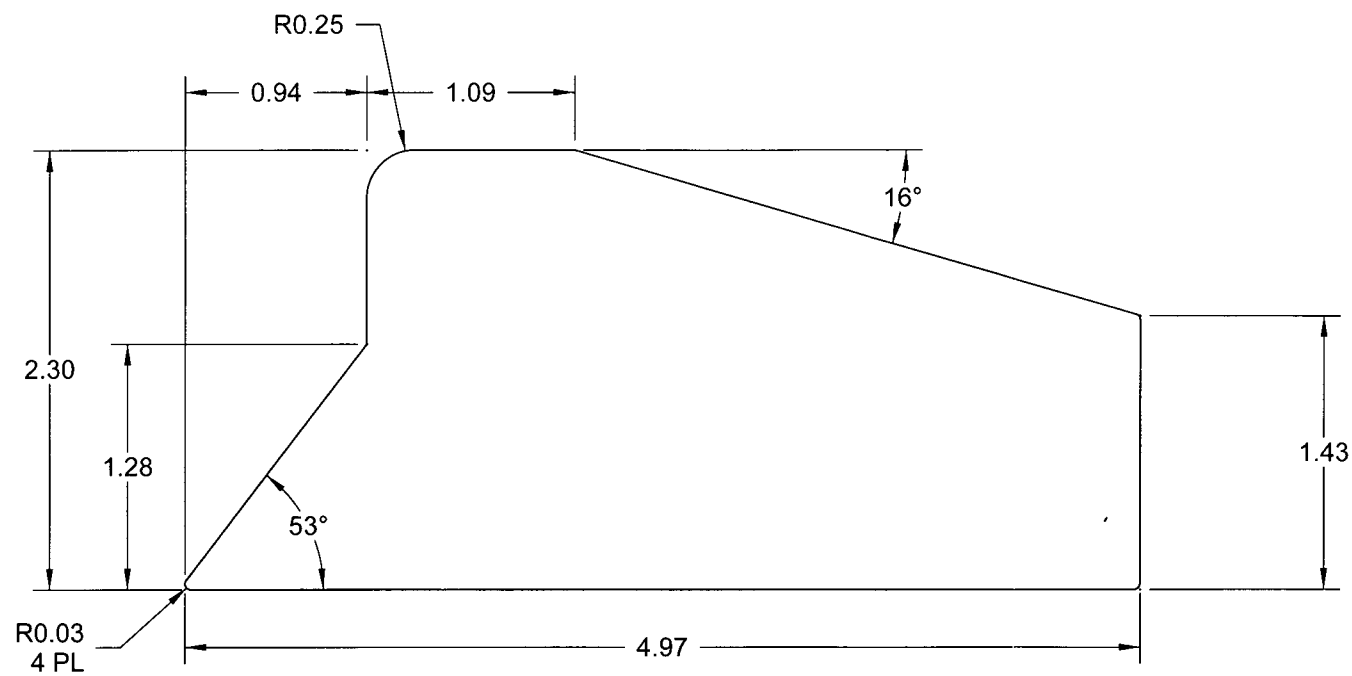
W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

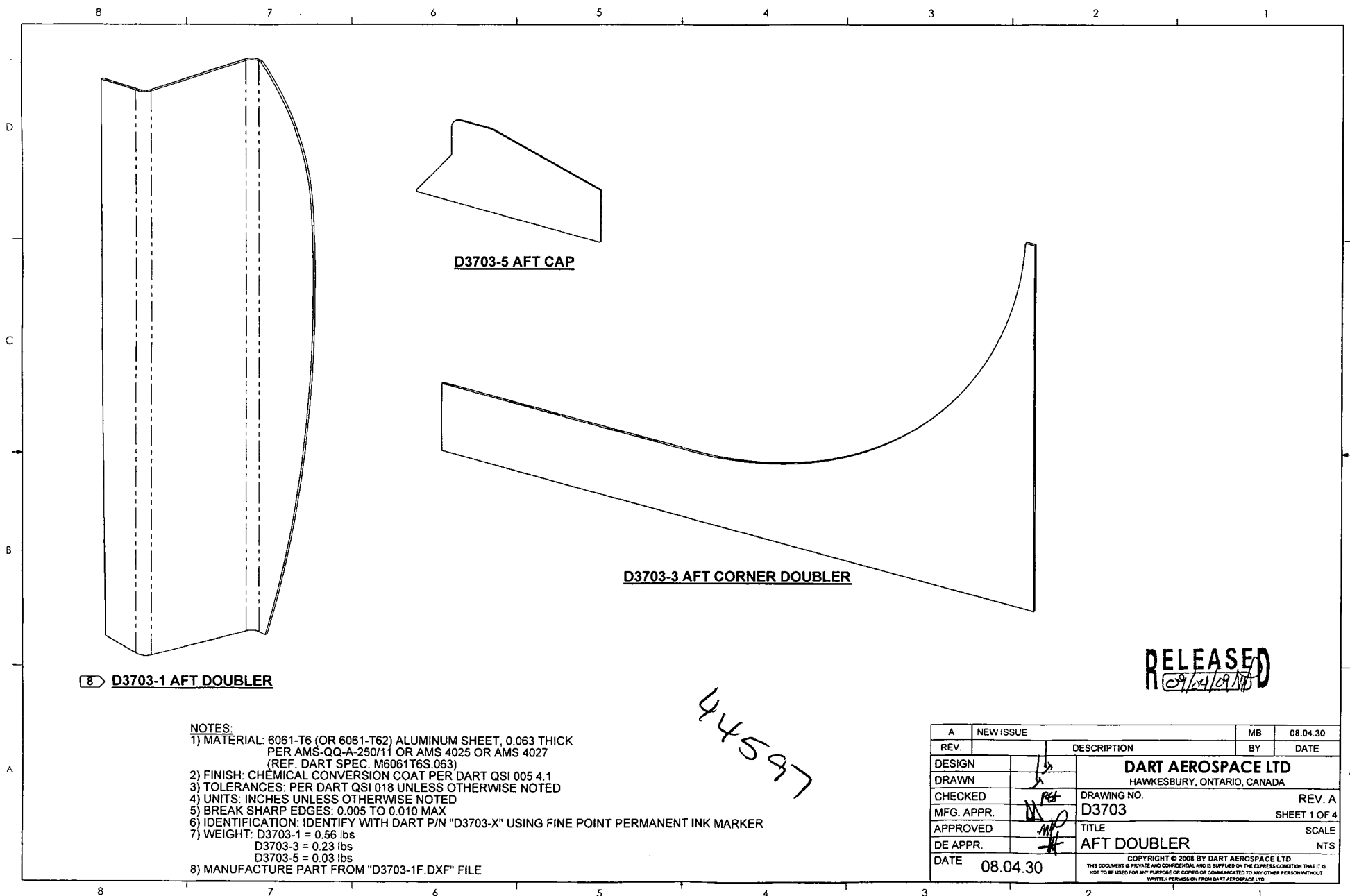
NOTE: Date & initial all entries



D3703-5 AFT CAP

PRELIMINARY ISSUE
for 01/12
for ECN #017022

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3703	SHEET 4 OF 4
APPROVED		TITLE	SCALE
DE APPR.		AFT DOUBLER	NTS
DATE	08.04.30	COPYRIGHT © 2008 BY DART AEROSPACE LTD <small>THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	



D3703-5 AFT CAP

D3703-3 AFT CORNER DOUBLER

D3703-1 AFT DOUBLER

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.063)
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" USING FINE POINT PERMANENT INK MARKER
 - 7) WEIGHT: D3703-1 = 0.56 lbs
D3703-3 = 0.23 lbs
D3703-5 = 0.03 lbs
 - 8) MANUFACTURE PART FROM "D3703-1F.DXF" FILE

RELEASED
09/24/09 MD

A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.04.30		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		REV. A
DRAWING NO.	D3703	SHEET 1 OF 4
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8 7 6 5 4 3 2 1

D

C

B

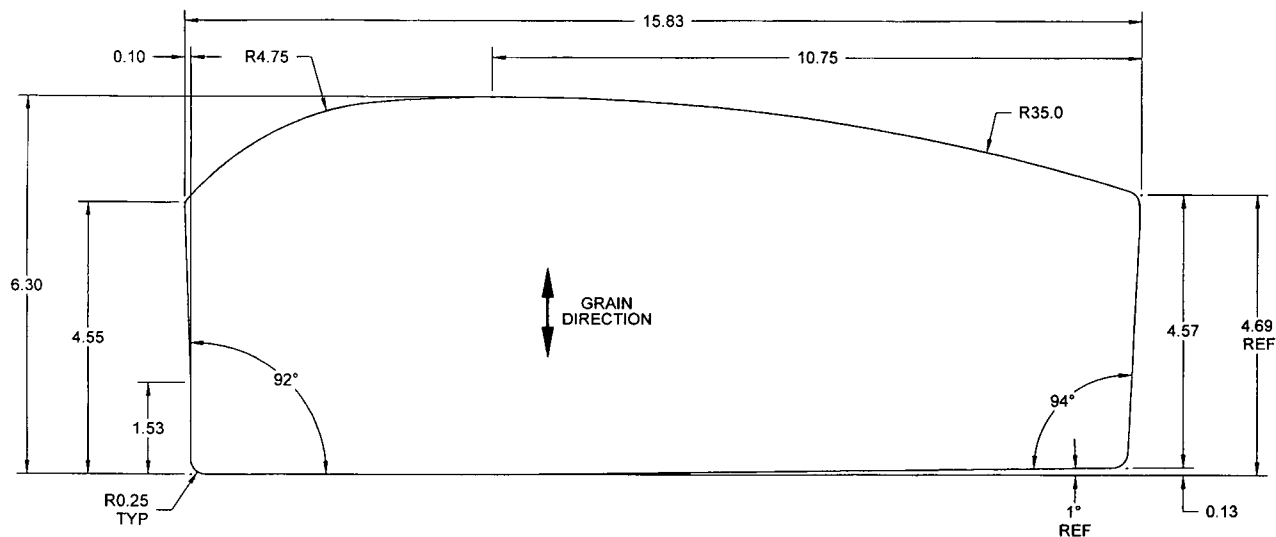
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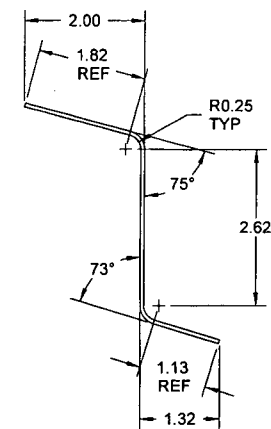
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D3703-1F AFT DOUBLER FLAT PATTERN



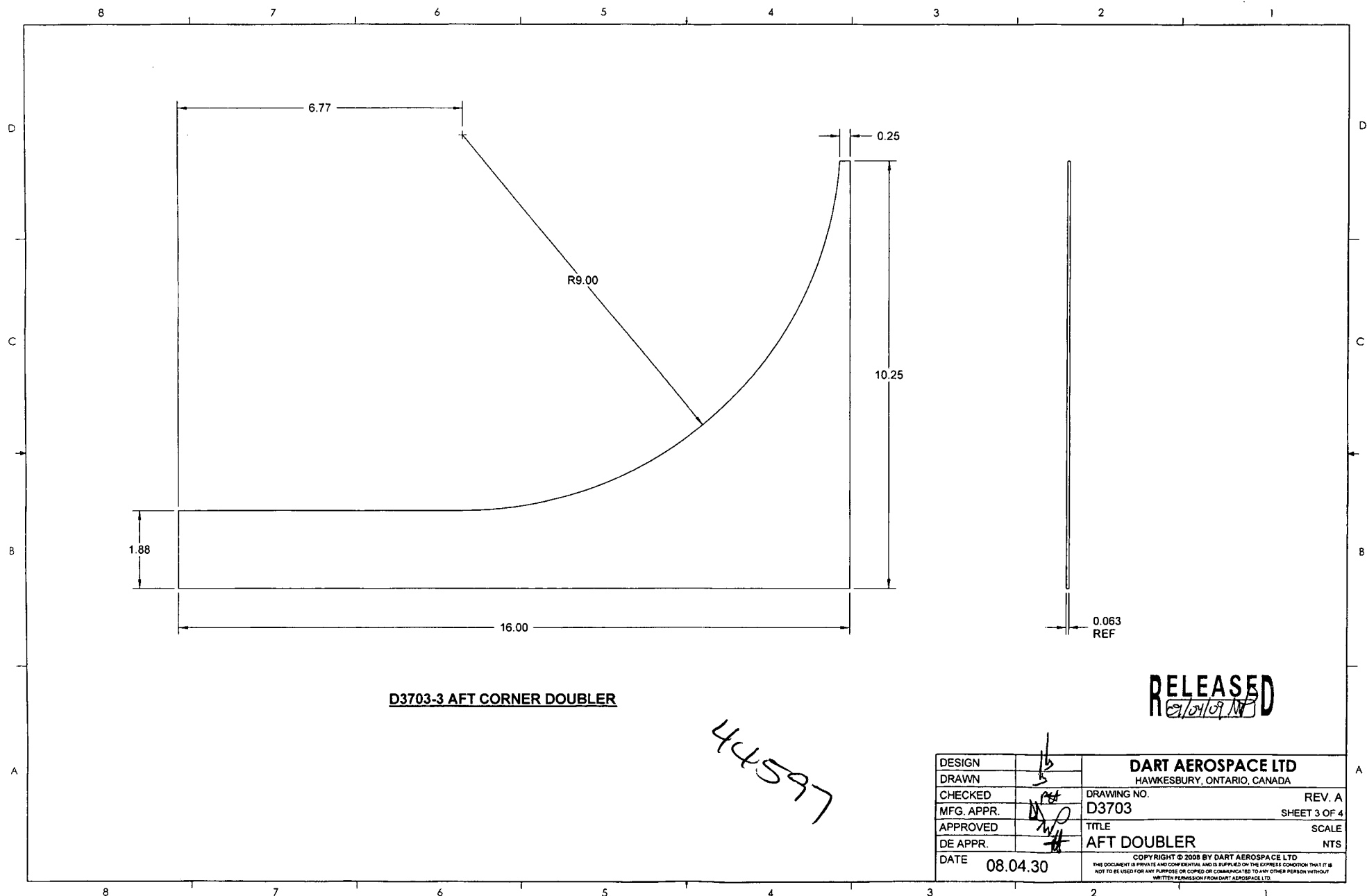
**D3703-1 AFT DOUBLER
(MAKE FROM D3703-1F)**

RELEASED
09/04/09

44597

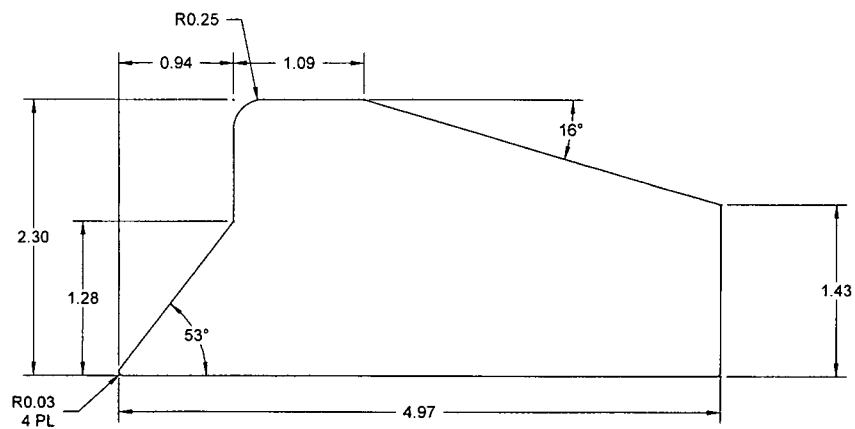
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8 7 6 5 4 3 2 1



RELEASED
07/07/09

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D3703-5 AFT CAP

44597

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09/24/09 AM

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